



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBE350A93-3302-02

Job Sheet 195791



Part No: RBE350A93-3302-02

Job Qty: 7 pcs

Part Name: Tail Rotor Hub Lock Wrench



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/30/19

Job Tracking No:

Due Date: 6/13/19

Created By: Linda Lacelle

Type: Stock

Description:

Note: DWG RBE350A93-3302-02 REV:11 IPP REV A 18.01.30 NEW ISSUE RQ VERIFIED BY DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	7 pcs	6/13/19		0.00	0.47	Small Fab - 1		MLL
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
110	QC 5	7 pcs	6/13/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
130	Packaging 3-1 - Stock - B4B	7 pcs	6/13/19		0.00	0.00	Packaging 3 - 1 - B4B		JUN 06 2019 DAS 40 9-89
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S186226



Part: RBE350A93 - 3302 - 02

Job No: 195791

Serial No/Batch: S186226

Revision: 11

Inspector:

Exp Date:

Instructions:

Date: 05/31/19

Plex 5/30/19 1:39 PM dart.leclair.mathieu

					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
140 QC 21 - FG	7 pcs	6/13/19	0.00 0.00		QC 21 - FG - 21	
					QC 21 - FG - 70	
					QC 21 - SA - 53	

Part Op 100 - Small Fab - Assemble

Descriptions: 110 - QC5- Inspect part completeness to step on W/O

130 - Identify as per dwg & Stock Location:

140 - QC21- Final Inspection - Work Order Release

DAS
21
9-80

JUN 06 2019

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
3896T31	Ferule 1/16 X 3/8" - Aluminum	28 Ea (4 ea)	100-Small Fab - 1	5150648
90174A113	Retaining Pin	14 Ea (2 ea)	100-Small Fab - 1	5187730
90177A218	Split Ring	28 Ea (4 ea)	100-Small Fab - 1	5059399
90272A189	Machine Screw	7 Ea (1 ea)	100-Small Fab - 1	5039398
94975A162	Quick Release Pin	7 Ea (1 ea)	100-Small Fab - 1	5145189 1X5039292
CL-2-C	Lanyard Wire	11.6620 ft (1.666 ea)	100-Small Fab - 1	5119833
RBE350A93-3302-02-1	Handle	7 pcs (1 ea)	100-Small Fab - 1	5164402
RBE350A93-3302-02-3	Pin	14 pcs (2 ea)	100-Small Fab - 1	5163181
RBE350A93-3302-02-5	Extension Handle	7 pcs (1 ea)	100-Small Fab - 1	51549060

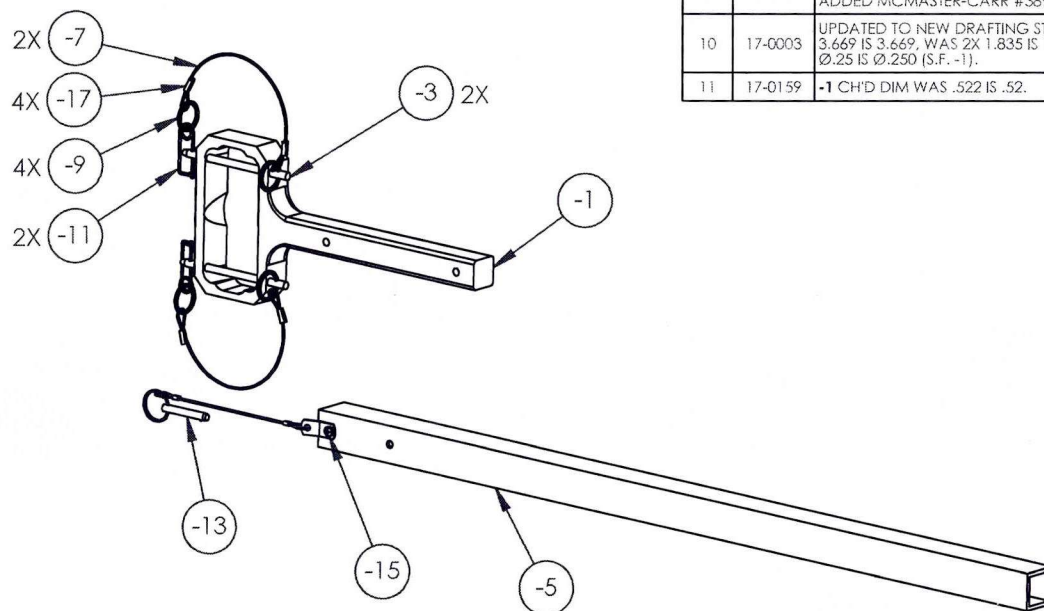
1X5114472
1X407992

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	3896T31	28	773	0
	90174A113	14	73	0
	90177A218	28	116	0
	90272A189	7	163	0
	94975A162	7	22	0
	CL-2-C	12	154	0
	RBE350A93-3302-02-1	7	7	0
	RBE350A93-3302-02-3	14	23	0
	RBE350A93-3302-02-5	7	27	0

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		-1 CH'D INSIDE ANGLED RADIUS FROM R.75 TO R.375, CH'D DIM WAS 1.122 IS 1.	12/5/2008	WP	DW
2		-1 ADDED Ø.250 HOLE. -5 ADDED #8-32 HOLE & Ø.250 HOLE.	3/18/2009	WP	DW
3		-1 ADDED 1 INCH SQUARE DIM, CH'D DIM TO 2.309. -5 CH'D OD & ID DIMS.	4/29/09	RJC	
4		-5 DELETED ENGRAVE NOTE.	6/1/2009	RJC	
5		-1 ADDED TOLERANCE 1.00 - .98 TO HANDLE. -3 SHORTENED PIN BY 3/8 ON BOTH ENDS. -5 EXTENDED FROM 16.1 TO 30.0, MOVED PIN HOLE FROM 1.25 TO 3.00, CH'D MATERIAL WAS STEEL IS ALUMINUM.	10/6/2009	WP	DW
6		-1 CH'D TOOLING HOLE WAS Ø.266 IS Ø.250. ADDED ENGRAVE NOTE. -5 ADDED ENGRAVE, CH'D TOOLING HOLE WAS Ø.266 IS Ø.250.	12/16/2010	RJC	RW
6A		-5 CH'D TUBE WALL THICKNESS WAS .105 IS .125.	5/10/2012	RJC	GEB2
7		-1 CH'D DIM WAS Ø.250 IS Ø.250 +.005 -.000.	4/18/2013	CFS	JG
8A		CORRECTED T/N WSS RBEA93-3302-02 IS RBE350A93-3302-02.	11/5/2013	RJC	RW
9	15-0131	-7 CH'D WAS MCMASTER-CARR #30345T15 IS CARR LANE #CL-2-C. -9 CH'D QTY. WAS 2 IS 4. -17 ADDED MCMASTER-CARR #3896T31.	6/12/2015	RJC	JAG
10	17-0003	UPDATED TO NEW DRAFTING STANDARD. -1 CH'D DIM WAS 3.071 IS 3.07, WAS 5.315 IS 5.32, WAS 2X 3.669 IS 3.669, WAS 2X 1.835 IS 1.835, WAS 4X .190 IS 2X .190. ADDED DIM .522. -3 CH'D DIM WAS Ø.25 IS Ø.250 (S.F. -1).	2/28/2017	RJC	SM
11	17-0159	-1 CH'D DIM WAS .522 IS .52.	6/21/2017	RJC	JAG



NOTE:

ORIGINAL No. REF: RBEA93-3302-2 = 350A93-3302-02.

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	HANDLE	6061		2
			-3	2	PIN	S.S.		3
			-5	1	EXTENSION HANDLE	ALUMINUM SQ. TUBE		4
		B/O	-7	2	LANYARD	COATED STEEL	Ø1/16 X 8 7X7 CABLE (CARR LANE #CL-2-C)	1
		B/O	-9	4	SPLIT RING	STEEL	Ø1 O.D. X 1/8 (MCMASTER-CARR #90177A218)	1
		B/O	-11	2	WIRE LOCKING PIN	STEEL	Ø1/16 X 1-1/16 USABLE (MCMASTER-CARR #90174A113)	1
		B/O	-13	1	QUICK RELEASE PIN W/LANYARD	S.S.	Ø1/4 X 1.3 USABLE (MCMASTER-CARR #94975A162)	1
		B/O	-15	1	MACHINE SCREW	STEEL	#8-32 UNC-2A (MCMASTER-CARR #90272A189)	1
		B/O	-17	4	FERRULE	ALUMINUM	Ø1/16 X 3/8 (MCMASTER-CARR #3896T31)	1

DART AEROSPACE	
TITLE T/R HUB LOCK WRENCH	
DWG NO. RBE350A93-3302-02	REV 11
MAT'L HEAT TREAT FINISH SPEC	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125/✓	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: PERRITT	CHECKED: DUERFELDT
OPPS APPR: ANDERSON	QA APPR: LINDSAY
APPROVED: MACKOVJAK	USED ON MODEL
SCALE 1:6	DATE 10/20/2008
SHEET 1 OF 4	